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D5162-041
Job Sheet 186531



Part No: D5162-041

Job Qty: 1 ea

Part Name: Seat Structure Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/16/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3016 REV (DEO) A1, D5162 REV A, D5189 REV A, D3017 REV C IPP REV:A 14.11.05 NEW ISSUE
DD VERF:JLM IPP REV:B 15-02-06 AS PER DWG REV.A DD VERF:JLMIPP REV:C 16.08.31 ADD D3016
PARTS DD VERF:JLM

Ship Via:

D07686

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/7/18	0.00	0.00	Start Up Large Fab-1		<i>CL</i>
110	Large Fab	1 pcs		12/7/18	24.00	4.63	Large Fab 4		<i>CL</i> DAS
140	QC	1 pcs		12/7/18	0.00	0.00	QC5		<i>38</i>
165	Large Fab	1 pcs		12/7/18	0.00	4.63	Large Fab 4		<i>CL</i> 9-89
170	QC	1 pcs		12/7/18	0.00	0.00	QC9		<i>CPC</i>
175	QC	1 pcs		12/7/18	0.00	0.00	QC5 N/A		
180	HandFinish	1 pcs		12/7/18	0.00	0.47	HandFinish1		<i>D.R. 19/01/23</i>
190	QC	1 pcs		12/7/18	0.00	0.00	QC7-5		<i>36</i> DAS
200	Small Fab	1 pcs		12/7/18	0.00	1.00	Small Fab-8		<i>9-89</i> 36
210	QC	1 pcs		12/7/18	0.00	0.00	QC5		<i>38</i> 9-89
220	Powdercoat	1 pcs		12/7/18	0.00	0.29	Powdercoat3		<i>FLA-01-23</i>
230	QC	1 pcs		12/7/18	0.00	0.00	QC3		<i>36</i> DAS
240	Small Fab	1 pcs		12/7/18	0.00	1.00	Small Fab-8		<i>9-89</i> 36
250	QC	1 pcs		12/7/18	0.00	0.00	QC5		<i>9-89</i> DAS
260	Packaging	1 pcs		12/7/18	0.00	0.00	Packaging3-2		<i>36</i>
270	QC21-SA	1 Ea		12/7/18	0.00	0.00	QC21		<i>CL 19.01.23</i>

M 138839 START: 11:20

OUT: 3:00

FINISH: 11:50

Job BOM

007642

Part / Item	Component Name	Quantity	Operation	Container
D2199-31	Strut Details	1 Ea (1 ea)	90-Start up Operation	<i>5020528</i>
D3016-1	Tube	2 Ea (2 ea)	90-Start up Operation	<i>5037209</i>
D3016-11	Saddle	2 Ea (2 ea)	90-Start up Operation	<i>5037785</i>
D3016-3	Tube	4 Ea (4 ea)	90-Start up Operation	<i>5019265</i>
D3016-5	Tube	2 Ea (2 ea)	90-Start up Operation	<i>5019171</i>
D3016-7	Tube	4 Ea (4 ea)	90-Start up Operation	<i>5019185</i>
D3016-9	Saddle	2 Ea (2 ea)	90-Start up Operation	<i>5037648</i>
D5159-041	Seat Back Brace Assembly	1 Ea (1 ea)	90-Start up Operation	<i>5096211</i>
D5159-043	Seat Back Brace Assembly	1 Ea (1 ea)	90-Start up Operation	<i>5096176</i>
D5159-045	Seat Rib Assembly	1 Ea (1 ea)	90-Start up Operation	<i>5099626</i>
M4130NT0.750W.049	4130 Round Tube .750 X.049W	13.8000 ft (13.8 ea)	90-Start up Operation	<i>5133775</i>
M4130NT0.750W.083	4130 Round Tube .750 X.083W	2.5000 ft (2.5 ea)	90-Start up Operation	<i>5060104</i>

DAS
70
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

D3016-13	Bracket	2 Ea (2 ea)	90-Start up Operation	5019205
D3016-15	Gusset	2 Ea (2 ea)	90-Start up Operation	5019171
D3016-17	Gusset	2 Ea (2 ea)	90-Start up Operation	5019185
D3017-11	Cap	4 Ea (4 ea)	90-Start up Operation	5019161
D3017-7	Lug	3 Ea (3 ea)	90-Start up Operation	5103092
D3020-1	Fitting	4 Ea (4 ea)	90-Start up Operation	5075006
D3022-1	Seat Pan	1 Ea (1 ea)	90-Start up Operation	2104772
D3023-1	Back Panel	1 Ea (1 ea)	90-Start up Operation	5092907
D4667-041	Armrest Stud Assembly	1 Ea (1 ea)	90-Start up Operation	5068443
D5190-1	Armrest Fitting	1 Ea (1 ea)	90-Start up Operation	5025769
D5190-3	Weld Pin	1 Ea (1 ea)	90-Start up Operation	F154143
MS20600-AD4W2	Rivet	40 46 Ea (46 ea)	200-Small Fab	
AN3-12A	Bolt	3 Ea (3 ea)	240-Small Fab	5095479
AN4-14A	Bolt	2 Ea (2 ea)	240-Small Fab	5114891
AN4-4A	Bolt	1 Ea (1 ea)	240-Small Fab	5104458
AN4-6A	Bolt	1 Ea (1 ea)	240-Small Fab	5053945
AN970-4	Washer	1 Ea (1 ea)	240-Small Fab	5114901
D3024-1	Spacer	3 Ea (3 ea)	240-Small Fab	5093168
D3031-1	Loop	2 Ea (2 ea)	240-Small Fab	5089714
MS20600-AD4W4	Rivet	4 Ea (4 ea)	240-Small Fab	5141239
MS20600-AD4W5	Blind Rivet	8 Ea (8 ea)	240-Small Fab	5016897
MS21042L3	Nut	17 Ea (17 ea)	240-Small Fab	5132364
MS21042L4	Nut	8 Ea (8 ea)	240-Small Fab	5132396
MS24693-S272	Screw	4 Ea (4 ea)	240-Small Fab	5074201
MS27039-1-17	Screw (601.1954)	1 Ea (1 ea)	240-Small Fab	511278364
MS27039-1-18	Screw	3 Ea (3 ea)	240-Small Fab	5124326
MS27039-1-19	Screw	4 Ea (4 ea)	240-Small Fab	5133205
MS27039-1-20	Screw	2 Ea (2 ea)	240-Small Fab	5094854
MS27039-4-20	Screw	4 Ea (4 ea)	240-Small Fab	5039035
MS27039-4-21	Screw	2 Ea (2 ea)	240-Small Fab	51135714
NAS1149D0332J	Washer	30 Ea (30 ea)	240-Small Fab	5113751
NAS1149D0432J	Washer	17 Ea (17 ea)	240-Small Fab	5093756
NAS43DD4-16FC	Spacer	2 Ea (2 ea)	240-Small Fab	5007039
MS20600-AD4W3		4x	200-SM	5000552

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2199-31	1	4	0
	D3016-1	2	6	0
	D3016-11	2	6	0
	D3016-13	2	17	0
	D3016-15	2	32	0
	D3016-17	2	44	0
	D3016-3	4	12	0
	D3016-5	2	6	0
	D3016-7	4	12	0
	D3016-9	2	6	0
	D3017-11	4	50	0
	D3017-7	3	27	0
	D3020-1	4	12	0
	D3022-1	1	3	0
	D3023-1	1	2	0
	D4667-041	1	8	0
	D5159-041	1	2	0
	D5159-043	1	1	0
	D5159-045	1	3	0
	D5190-1	1	12	0
	D5190-3	1	2	0
	M4130NT0.750W.049	14	40	0
	M4130NT0.750W.083	3	15	0
200-Small Fab	MS20600-AD4W2	46	367	0
240-Small Fab	AN3-12A	3	88	0
	AN4-14A	2	921	0
	AN4-4A	1	30	0
	AN4-6A	1	694	0
	AN970-4	1	138	0
	D3024-1	3	6	0
	D3031-1	2	18	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

MS20600-AD4W4	4	2,558	0
MS20600-AD4W5	8	139	0
MS21042L3	17	1,880	0
MS21042L4	8	1,888	0
MS24693-S272	4	105	0
MS27039-1-17	1	59	0
MS27039-1-18	3	1,218	0
MS27039-1-19	4	304	0
MS27039-1-20	2	97	0
MS27039-4-20	4	70	0
MS27039-4-21	2	21	0
NAS1149D0332J	30	1,937	0
NAS1149D0432J	17	837	0
NAS43DD4-16FC	2	16	0

Part Specifications

Specifications could not be found.

Plex 11/16/18 1:14 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (Q61043) Approval _____	
Description Work Order Deviation					
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unqualified ☐ Drill Holes ☐	Power Loss/Stage ☐ Folio/Program ☐ Grain ☐ Weld ☐ Lock Pull ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/function ☐ Material ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part incorrect ☐ Missing ☐			
OTHER : ☐		Container No: S146810 Part: D5162-041 Job No: 186531 Serial No/Batch: S146810 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 01/22/19			

